Quality Control

122458 Work Order ID 122458 July-21-14 9:00:31 AM Setup Start Accept *N900040100* D3490-3 Item ID: **Revision ID:** Cross Bolt Spacer Item Name: *40* **Start Qty: 40.00** Cust Item ID: 7/21/14 **Start Date:** Required Date: 7/21/14 Req'd Qty: 40.00 *40* **Customer:** Reference: Start Run Date: 14-07-21 Tooling: Date: Process Plan: MLJ Approvals: Stop Date: SPC (Y/N): QC: Date: Accept Reject Reject Insp. Tool ID Tool # Plan Operation Set Up/ Sequence ID/ Oty Number Stamp Code **Qty Run Hours** Description Work Center ID **Revision Nbr Draw Nbr** D3490 Rev A DAS 0.00 100 ET 14.07.24 Hardinge CNC LATHE SMALL *100* 0.00 Hardinge Memo 1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV: Hardinge CNC Lathe Small DWG REV: 2-DEBURR AS REQUIRED DAS ST 14-07-24 02 9-89 0.00 QC2- Inspect parts off machine FAI/FAIB 110 *110* 0.00 QC Memo Quality Control 0.00 QC8- Inspect parts - second check 40 120 *120* 0.00 QC Memo

Page 1

DQA:			Date:							DD 4 TE					ART
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		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorre	cí _		ature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified		Part Lost/M	issing	Weld	
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		Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence						

Work Order ID 122458

122458

July-21-14 9:00:31 AM

Setup Start *N900040100* Accept D3490-3 Item ID: **Revision ID:** Cross Bolt Spacer Item Name: *40* **Cust Item ID: Start Qty: 40.00** 7/21/14 **Start Date:** Req'd Qty: 40.00 **Customer:** Required Date: 7/21/14 *40* Reference: Start Run Date: **Tooling:** Date: **Process Plan:** Approvals: Stop Date: SPC (Y/N): Date: Accept Reject Reject Tool ID Tool # Plan Set Up/ Operation Sequence ID/ Number Stamp Oty Code Qty **Run Hours** 14-7-25 DC Description Work Center ID 0.00 124 *124* 0.00 HandFinish Memo CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANNER Hand Finishing 0.00 OC5- Inspect part completeness to step on W/O 8 BE14-08-15 126 *126* 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: 0.00 D BE14-08-15 130 *130* 0.00 Packaging Memo ***STOCK IN SKIDTUBE CELL*** Packaging

DQA:			Date:							DD 4 T F					DART
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Work Order ID 122458

122458

July-21-14 9:00:31 AM

N900040100 Setup Start Accept Item ID: D3490-3 **Revision ID:** Cross Bolt Spacer Item Name: *40* **Cust Item ID: Start Qty: 40.00** 7/21/14 Start Date: **Customer:** Req'd Qty: 40.00 *40* Required Date: 7/21/14 Reference: Start Run Date: **Tooling:** Date: Process Plan: Approvals: Stop SPC (Y/N): Date: Date: Reject Reject Insp. Accept Tool ID Tool # Plan Set Up/ Operation Sequence ID/ Number Stamp Qty Qty Code **Run Hours** Description Work Center ID MCJ 14-08-15 0.00 OC21- Final Inspection - Work Order Release 140 *140* 0.00 QC Memo Quality Control

DQA:			Date:												DART
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July-21-14 9:00:36 AM

Work Order ID: 122458

D3490-3

Parent Item Name: Cross Bolt Spacer

122458

D3490-3

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 40.00

Required Qty: 40.00

Comments:

Parent Item:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	48.5981	0.266 _{DAS}	12	1	. 7	γd
*M6061T6	R0 750	*							** 02 9-8	9	19 -	07	-24

Loc Code Loc Oty **Location** 48.598052 MAT012 3.494052 m126852 24 m128573 21.104 m129167

Page 1

DQA: Date:						WORK ORDER NON		"DART							
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1	Wave/Twist in Tube			- 1	Fit/Function		IOut of	Out of Sequence							

DART AEROSPACE LTD	Work Order:	122458
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

х	First Article	Prototype
	FIRST Article	Flototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.085	+0.030/-0.000	3.093			vem	85-4
0.080	+/-0.010	0.075				
Ø0.591	+0.008/-0.001	0.593				
0.050 x 45°	+/-0.010 x 0.5°	0.046				
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DAS

Measured by: 702
9-89

Date: 14-07-14

Date: 14/07/15

Prototype Approximation 14/07/15

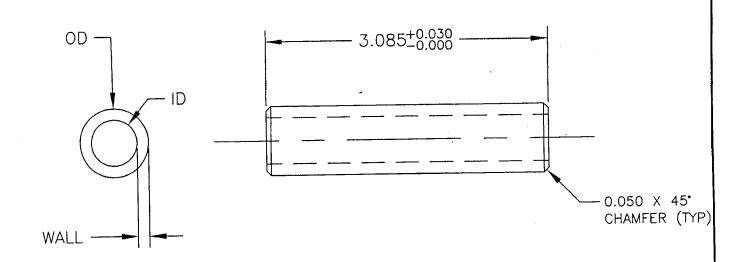
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.27	New Issue	KJ/JLM 🛠	- <i>41</i> /

DQA:	QA: Date:								•				TRAC"
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		Crushing				Countersink		Misali	gned/off center	Γ	Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
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		Turning S	Sequence			Finish ,		Out of	Calibration				
		Wave/Tv	vist in Tub	oe		Fit/Function		Out of	Sequence				



	DESIGN	PH	DRAWN BY	DART AEROSPACE US	SA, INC.
	CHECK		APPROVED	DRAWING NO. D3490	REV. A SHEET 1 OF 1
1	DATE			TITLE	SCALE
	06.0	01.04		CROSS BOLT SPACER	NTS
	Δ		06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

ROSS BOLT SPACER
ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) S
S ARE IN INCHES MATERIAL:

ALL DIMENSIONS ARE IN INCHES 2)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3)



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DQA:			Date:										DART
						WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			Work Order update only							
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
				Rework			Skid-tube Crosstube]	Water Jet	Engineering		
Part No.				Scrap Use-as-is			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality		
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		Crushing				Countersink		`	gned/off center	<u> </u>	Positioned Wrong		
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